

Work Order ID 76191

\*76191\*

Page 1

November-07-11 11:27:13 PM

Item ID: D2933-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Saddle LH In, 206

Start Date: 07/11/2011 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 21/11/2011 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan: M.C.J.

Date: 11/11/08 Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

B.A 12/02/02

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

6

φ

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

B.A 12/02/02

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

6

φ

120

0.00

\*120\*

QC1- Inspect dimensions to dimension sheet

B.A 11/02/02

QC

Memo

0.00

Quality Control

6

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76191

November-07-11 1:27:13 PM

**\*76191\***

Page 2

Item ID: D2933-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle LH In, 206  
 Start Date: 07/11/2011 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 21/11/2011 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>mk 12/02/05</i>			<u>6</u>	<u>0</u>		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>6</u>	<u>0</u>	<u>CF 12-2-6</u>	
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo	0.00  0.00							

START TIME: 2:50 OVEN TEMPERATURE:  
 FINISH TIME: 3:20

*3200F*

*6X 0 m-12/02/06*

*will 9480*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 76191

\*76191\*

Page 3

November-07-11 1:27:13 PM

Item ID: D2933-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle LH In, 206  
 Start Date: 07/11/2011 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 21/11/2011 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
*160*									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 428	0.00							
*170*									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
*180*									
QC	Memo	0.00							
Quality Control									

6 BK 12-2-6

12/2/6 SP (6)

12/2/11 DJ

12-02-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 07-11 1:27:17 PM

Page 1

Work Order ID: 76191

\*76191\*

Parent Item: D2933-1

\*D2933-1\*

Parent Item Name: Saddle LH In, 206

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC  
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	162.0000	1	6			
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\*D6101-001\*

Saddle Billet

\*\*

h.a 12/02/02

## Location

## Loc Qty

## Loc Code

MAT040

162

66965

1

69677

2

73774

60

74648

31

74679

68

→ 78158

6.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76191
<b>Description:</b> 206 Saddle, Inboard, Left side		<b>Part Number:</b>	D2933-1
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>	

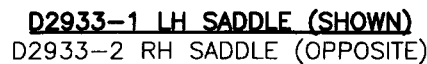
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
                         
 ☐ **Prototype**

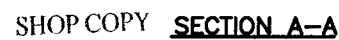
				Record Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
A	0.100	0.140		0.130	0.130	0.130	0.130	0.130	0.130
B	0.100	0.140		0.127	0.127	0.127	0.127	0.127	0.127
C	0.100	0.140		0.116	0.115	0.116	0.118	0.120	0.120
D	0.210	0.230		0.225	0.225	0.225	0.225	0.225	0.225
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.260	0.260	0.260	0.260	0.260	0.260
L	0.312	0.317		0.314	0.314	0.314	0.314	0.314	0.314
M	0.235	0.240		0.237	0.237	0.237	0.237	0.237	0.237
N	0.100	0.140		0.125	0.125	0.125	0.125	0.125	0.125
O	0.540	0.560		0.548	0.548	0.548	0.548	0.548	0.548
P	0.490	0.510		0.498	0.497	0.497	0.499	0.498	0.498
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		0.254	0.254	0.254	0.254	0.254	0.254
T	0.100	0.180		0.135	0.135	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	0.316	0.316	0.316	0.316
X	1.125	1.145		1.136	1.136	1.136	1.136	1.136	1.136
Y	1.565	1.585		1.576	1.576	1.576	1.576	1.576	1.576
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188	0.188
AA									
AB									
AC									
AD									
AE									
Accept/Reject									

<b>Measured by:</b> B.A	<b>Date:</b> 12/02/02
<b>Audited by:</b> <i>SMR</i>	<b>Date:</b> 12/02/05
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>[Signature]</i>



- 
- UNCONTROLLED  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
NO. 1
- 05 4.3  
EP
- 0.510 $\pm$ 0.005  
0.000
- 48.0°
- 1.605 $\pm$ 0.005  
0.000
- RO.025
- 0.115
- 0.240  
0.235
- 0.500
- 1.000
- 0.140  
0.100
- R1.575
- RO.50  
(TYP)
- RO.188  
(AROUND POCKET)
- A  
B  
C



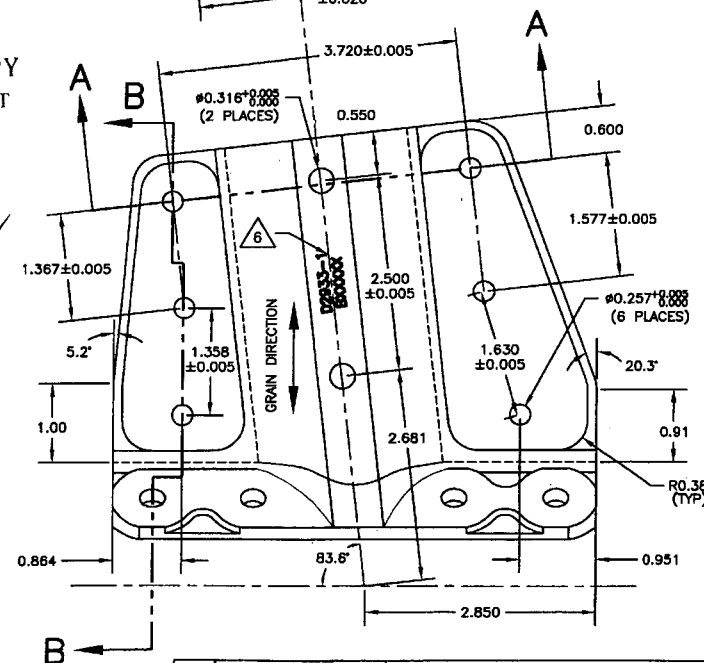
RETURN TO


## ENGINEERING

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WITHOUT NOTICE  
WORK ORDER

NO. 70191



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> BELLFLE, WA
<i>PH</i>	<i>CB</i>	
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D2933
DATE		TITLE
06.11.09		SADDLE INSIDE

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